

Work Order ID 127961

December-18-14 9:57:15 AM

Black Smiley
ASAP
127961

Page 1

Item ID: D2888 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lug
 Start Date: 12/18/14 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 12/26/14 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2888	Rev A2								

100 0.00
100
 Bandsaw
 Jeaspa Bandsaw
 Memo
 Cut Blanks at 4.200" long
 Grain along 4.200"*
and 14/12/20 *8 0*

110 0.00
110
 HAAS 1
 HAAS CNC vertical machine #1
 Memo
 Machine as per Folio D2888
 Folio Rev: *AA*
 Dwg Rev: *AA*
 2-Deburr
and 14/12/21 *8 0*

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120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				8	0		
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				8	0		DAS 08 9-89
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				8	0	14-12-23	DAS 34 9-89

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	White Gloss (Ref 4.3.5.1) per QSI005 4.3-Alum <i>Black Sandex</i> Memo <i>11/27/892</i> ATTENTION: BLACK SAND EX! START TIME <i>2:05</i> OVEN TEMPERATURE <i>3200</i> FINISH TIME <i>2:35</i>	0.00 0.00				<i>8</i>	<i>14-12-23</i>	<i>234</i>	<i>0.00</i>
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>8</i>	<i>DEC 24 2014</i>		DAS 9 9-89
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <i>227</i> Memo	0.00 0.00				<i>8</i>	DAS 06 9-89		JAN 06 2015

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

15/1/16 J

MF
15-01-06

Picklist Print

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Page 1

Work Order ID: 127961

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Parent Item: D2888

D2888

Parent Item Name: Lug

Start Date: 12/18/14

Required Date: 12/26/14

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP C00.06.22Removed P/O for powder coatEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.500X03.50 0		Purchased		No		100	f	16.9000	0.39	4			

M6061T6B2 500X03 500

6061-T6 Bar 2.50 x 3.50

[Signature]
12/12/14

Location

Loc Qty

Loc Code

MAT004

16.9

m126724

4.9

m129530

12

2,844'

DART AEROSPACE LTD		Work Order: 127961
Description: Lug		Part Number: D2888
Inspection Dwg: D2888 Rev: A2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

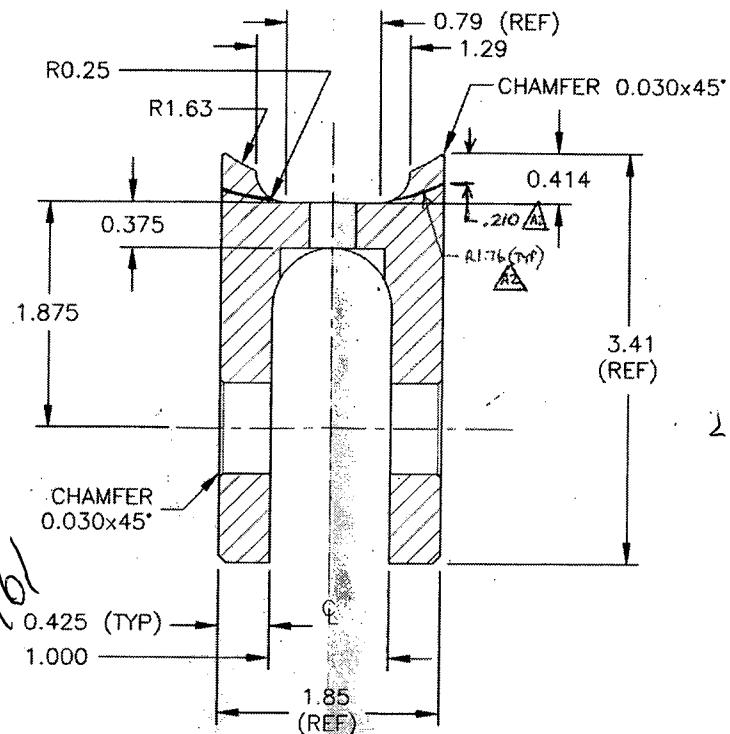
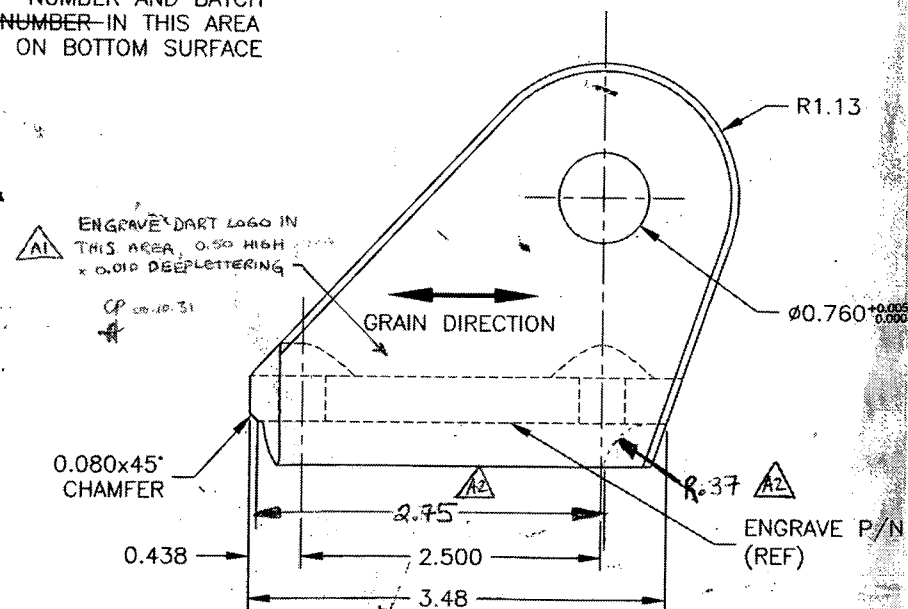
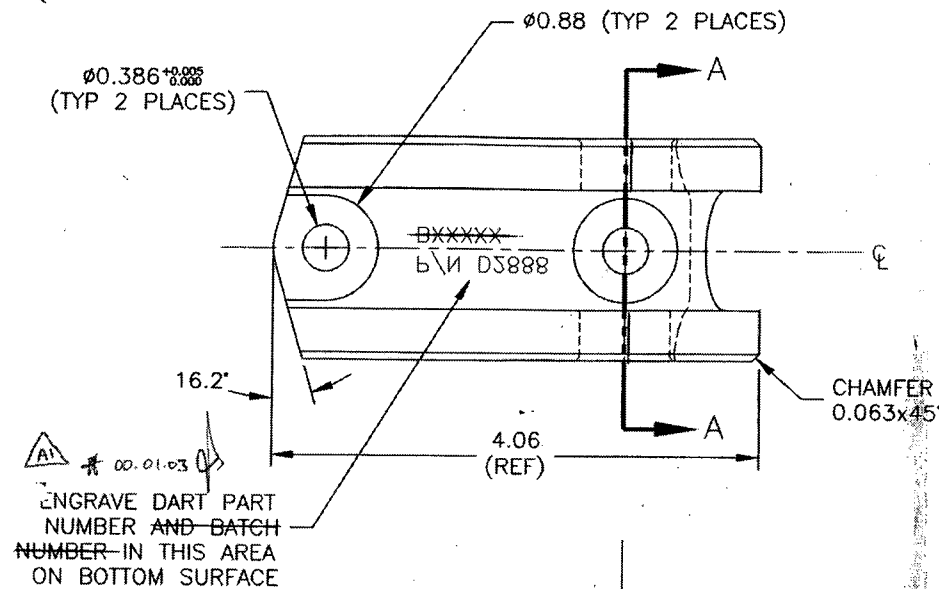
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.386	+0.005/-0.000	.387	✓			
Ø0.88	+/-0.030	.875	✓			
0.063 x 45°	+/-0.010	.063, 45°	✓			
4.06	+/-0.030	4.058	✓			
Ø0.760	+0.005/-0.000	.761	✓			
3.48	+/-0.030	3.478	✓			
2.500	+/-0.010	2.501	✓			
2.75	+/-0.030	2.735	✓			
0.438	+/-0.010	.433	✓			
0.080 x 45°	+/-0.010	.085	✓			
1.85	+/-0.030	1.850	✓			
1.000	+/-0.010	1.000	✓			
0.425	+/-0.010	.425	✓			
0.030 x 45°	+/-0.010	.020	✓			
1.875	+/-0.010	1.876	✓			
0.375	+/-0.010	.370	✓			
R0.25	+/-0.030	.250	✓			
1.29	+/-0.030	1.286	✓			
0.414	+/-0.010	.404	✓			
3.41	+/-0.030	3.410				

Measured by: [Signature]
Date: 14/12/21

Audited by: [Signature]	DAS
Date: 14/12/23	08 9-89

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.06.04	New Issue	KJ/DD [Signature]	[Signature]



SECTION A-A
SCALE 1:1

RELEASED
99.07.09 DS

MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005.4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005.4.3
BREAK UNMARKED EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

A2	04.04.08	Add Saddle Clearance for NCR 754
A1	00.10.31	Update Engraving 00.10.31

A	99.06.21	NEW ISSUE
DESIGN	DRAWN BY CP	DART DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED	APPROVED KE	DRAWING NO. D2888
DATE	99.06.21	TITLE LUG

REV. A
SHEET 1 OF 1
SCALE
1:1